Qty:

Monday, 5/1/2006 4:23:47 PM

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 26918

Estimate Number

: 10406

P.O. Number

:NA

: 5/1/2006 This Issue Prsht Rev.

: NC

NIA

S.O. No. : N/A

Type

: MACHINED PARTS

Part Number

Drawing Name

: D2415

Drawing Number Project Number : D2415 REV. A : N/A

: END PLATE

Drawing Revision

:NIA

Material **Due Date**

: 6/30/2006

14 Um:

Each

Written By

First Issue

Previous Run

Checked & Approved By

Comment

: Est:C 03.04/14/

D2375-3-08-106; D2403 - D2417 KJ/RF

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M5052H32S063

5052-H32 .063 Sheet



Comment: Qty.:

0.3253 sf(s)/Unit Total: 4.5541 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.063" thick

(M5052H32S.063)

Batch: MIL451

96 05

2.0

3.0

SHEAR

SHEAR



Comment: SHE

Cut blank: 7.320" x 5.540

HAAS CNC VERTICAL MACHINING #1



HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA159 and Dwg D2415 Wa7

Stack of 7 Identify as D2415

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8



5.0

SECOND CHECK



Comment: SECOND CHECK



Page 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHA	NGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		44					
						1	
Part No	:	PAR #: Fault Category:	NCR: Yes	No) DQ	A: 2	ී_ Date: <u>උ</u>	<u>4692</u> 3
				◯ N/C Close		_ Date:	<i>,</i>

NCR:			WORK ORDI	ER NON-CONFORMANCE (N	NCR)		1	· · · · · · · · · · · · · · · · · · ·
	,	Description of NC		Corrective Action Section B	,	V164	Annewal	Annrova
DATE	STEP	Section A	Initial Chief Eng		ign & Date	/erification Section C	Approval Chief Eng	Approva QC Inspecto
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NOTE: Date & initial all entries

Monday, 5/1/2006 4:23:48 PM Date: Kim Johnston User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: END PLATE Job Number: 26918 Part Number: D2415 Job Number: Seq. #: Description: **Machine Or Operation:** SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 6.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack INSPECT WORK TO CURRENT STEP 7.0 QC5 06.05.25 Comment: INSPECT WORK TO CURRENT STEP 8.0 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_ DOCUMENT CONTROL 9.0 DC Comment: DOCUMENT CONTROL Inspection Level 21 U D(00529 Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:	
			QA: N/C Closed:	Date:	

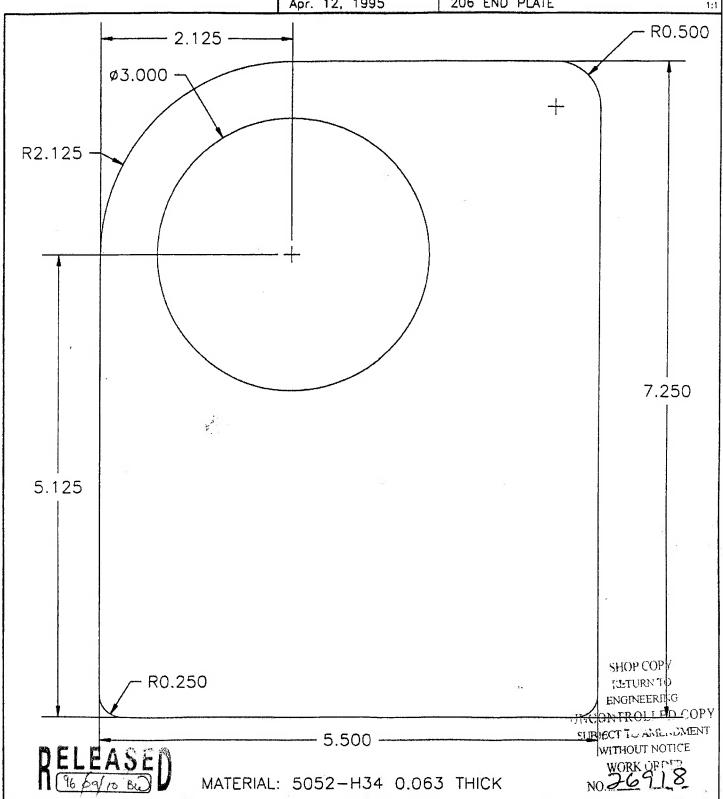
		WORK ORDE	ER NON-CONFORMAN	CE (NCR)	,	Ī	
	Description of NC		Verification		A		
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
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	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Corrective Action Section B Section A Initial Action Description	STEP Description of NC Corrective Action Section B Initial Action Description Sign &	STEP Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Initial Action Description Sign & Verification Section C Chief Eng

NOTE: Date & initial all entries

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PREPARED		DART AERO AC	CESSORIES INC
B. William	S		NAL AIRPORT, CANADA
CHECKED	APPROVED		REV. A
BW	BW	D2415	SHEET 1 OF 1
DATE	· · · · · · · · · · · · · · · · · · ·	TITLE	SCALE
Anr 12	1995	206 END PLATE	1.1



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DART AEROSPACI	E LTD	Work Order:	26918
Description:		Part Number:	2415
Inspection Dwg:	Rev:		Page 1 of 1

	FIRST	ARTICLE IN	SPECTIO	N CHE	CKLIST		
	Х	First Artic	le X	Prote	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	nments
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Date:	06 05 23	Date:	06-05-2	4	Da	ate:	
Ray Date	Change					ised by	Approved
A	New Issue				K1/1	LIVI	1